

Date: Monday, 1/7/2008 3:38:06 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD X-TUBE
Job Number : 36619	
Estimate Number : 10006	
P.O. Number : N/A	Part Number : D2889
This Issue : 1/7/2008 S.O. No. : N/A	Drawing Number : D2889 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : B
Previous Run : 36618	Material : N/A
Written By : <u>JD 08.01.8</u>	Due Date : 1/14/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JD 08.01.8</u>	
Comment : Est Rev A New Issue 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6005180	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube material

Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	B23963X2

★
 EL 8-1-8

2.0	BENDING	BENDING MACHINE
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PTC

Comment: LANDING GEAR RESOURCE 1

1-Bend D2889 as per Dwg D2889 and Folio FT001

EL 8-1-8

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

N/A

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

08.01.08 @

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1
 Inside and outside of tube

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2889 PAR #: 156 Fault Category: Roll/Landing gear NCR: Yes ☒ No ☐ DQA: D Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR: <u>N/A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-01-08</u>	<u>2.0</u>	<u>1.5"</u> X-tube over bent by <u>30"</u> , scrap. R.C. to bring the tube into tolerance. the program that was run, turned out to be an older one, having to much power, from one program to the next	<u>[Signature]</u> <u>08/01/09</u>	<u>delete program from file</u> <u>scrap & destroy</u> <u>replace qty 1 B 23963</u> <u>Programs to be worked</u> <u>on in accordance with PAR 156</u>	<u>EL</u> <u>8-1-8</u>	<u>[Signature]</u> <u>08-01-09</u>	<u>[Signature]</u> <u>08/01/09</u>	<u>[Signature]</u> <u>08-01-08</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 36619

Part Number: D2889

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/O 36468

(- 105)

08-01-08

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8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/01/11

Job Completion



2008/1/10

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

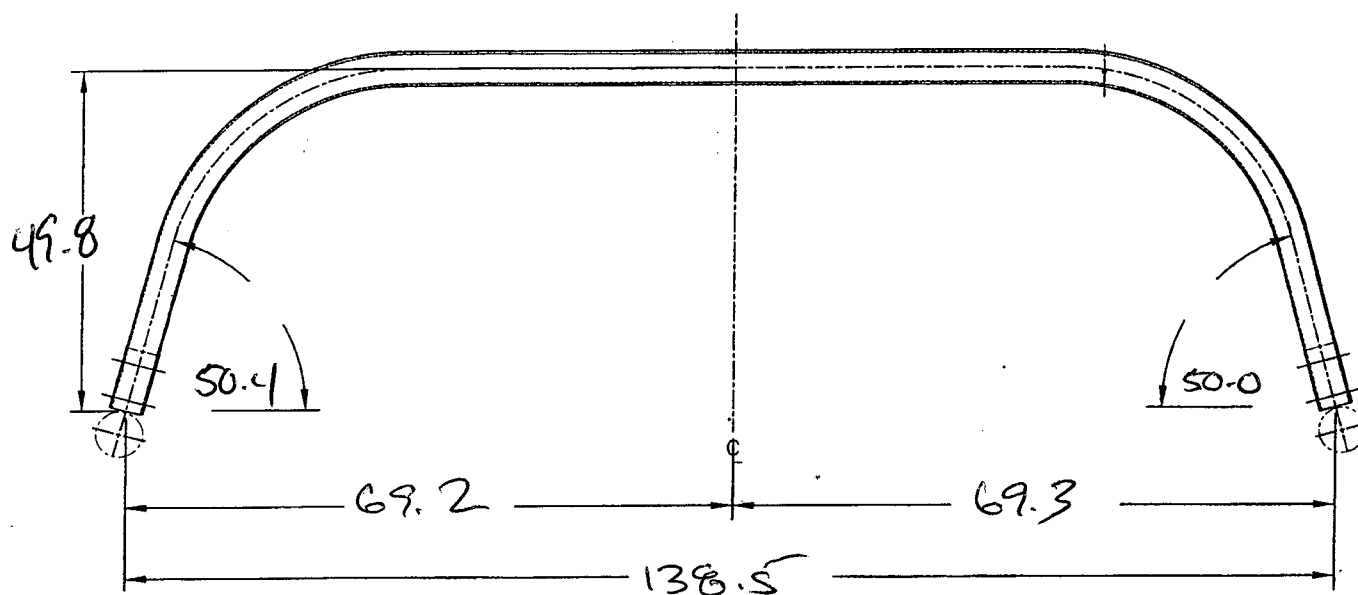
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

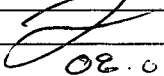
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36619
Description: Crosstube Fwd		Part Number:	D2889
Inspection Dwg: D2889 Rev: B		Page 1 of 1	


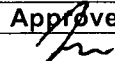
Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
good for -105, actually it's perfect for -105

QC15 Inspection	
Date	

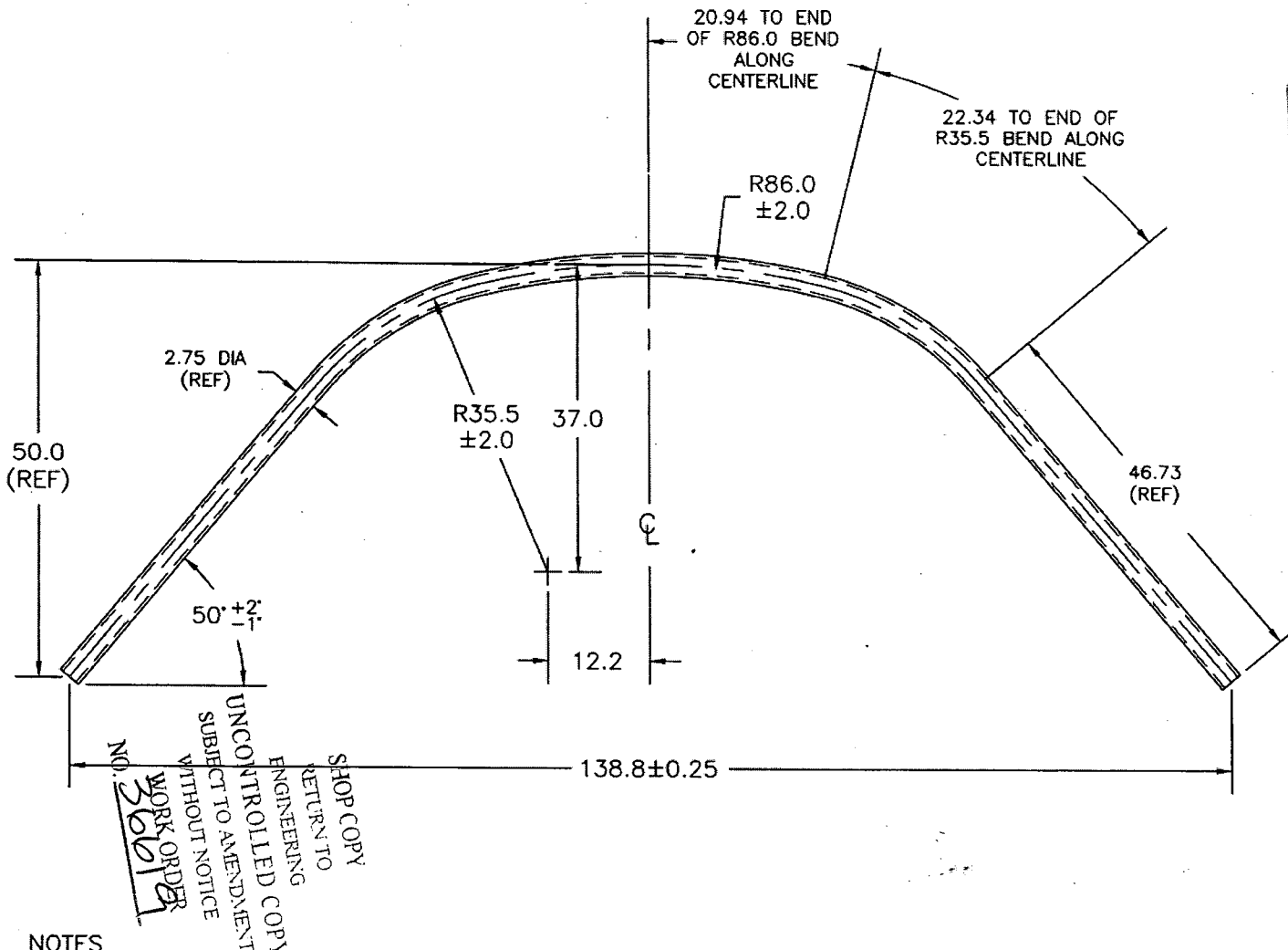
08.01.08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM 	



RELEASED
02.10.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		DATE		TITLE	
02.10.18		99.05.21		FWD CROSSTUBE	
A		02.10.18		NEW ISSUE	
B		ADD TANGENT LENGTHS; CHANGE NOTES		REV. B	
				SHEET 1 OF 1	
				SCALE	
				1:20	



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ($\phi 2.75$ OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.